

# Work Order ID 81394

\*81394\*

Page 1

March-14-12 7:46:33 AM

Item ID: D350-636-011

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube LH

Start Date: 13/03/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: MJS

Date: 12/03/14 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750	F								
D3492	C								

100

0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-011 CHG 006

Handwritten: Jdr CL 12-4-9

Handwritten: Z S 12/03/14

Handwritten: B 81394

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 81394**

March-14-12 7:46:33 AM

**\*81394\***

Page 2

Item ID: D350-636-011

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube LH

Start Date: 13/03/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110

0.00

**\*110\***

Skidtubes

0.00

Skidtubes

Memo

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

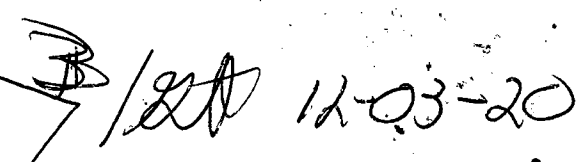
6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 &amp; DT8863A for first side only DT8863B for second side (detail B)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.  
\*\*\*SECOND SIDE\*\*\*

8-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail C to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)



W/O:		WORK ORDER CHANGES					
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Item ID: D350-636-011

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop **\*NS2\***

Start Date: 13/03/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left  
from bending as per QSI 004

A/R Aluminum Rod batch: *MB0164*

12-Grind welds flush as per Dwg D2750

*BB 12/03/22*  
*CF 12-3-22*

120

QC10- Inspect visual per QSI004- ground welds

0.00

**\*120\***

QC

Memo

0.00

Quality Control

*CP 12-03-22*

*1x*

130

QC5- Inspect part completeness to step on W/O

0.00

**\*130\***

QC

Memo

0.00

Quality Control

*DP*

*12-3-23*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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March-14-12 7:46:33 AM

Item ID: D350-636-011

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube LH

Start Date: 13/03/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N): Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

HandFinish

Memo

0.00

Hand Finishing

16 12-3-22

150

QC3- Inspect Part Finish

0.00

**\*150\***

QC

Memo

0.00

Quality Control

DP 12-3-22

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Item ID: D350-636-011

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop **\*NS2\***

Start Date: 13/03/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
<b>*160*</b>									
Skidtubes	<b>Memo</b>	0.00							
Skidtubes	1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	2-Open up holes of Detail B to 0.750" (total of 4 holes per side) as per dwg D2750.								
	3- Open float hole to 0.500" (4 per side)								
	4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on sheet 8)								
	5-Deburr and blow out all chips from inside of tube								
	6- Prepare tube for welding, remove alodine as required.								
	7-Bond web D2739 in place as per QSI015 A/R Sikaflex-291 batch: <u>M120513</u> exp. date: <u>12-04-13</u>								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 8) A/R Aluminum Rod batch: <u>M120164</u>								
	9- At section AJ-AJ drill out x-bolt spacer to 0.404"								
	10-Grind welds flush as per Dwg D2750								

*12/03/22*

*12-3-22*

*12-03-24*

*12.3.26*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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March-14-12 7:46:33 AM

Item ID: D350-636-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop **\*NS2\***

Start Date: 13/03/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

11-Spot face ground handling holes section (total of 4 places per side) as per  
dwg D2750

12-Deburr holes

170

QC10- Inspect visual per QSI004- ground welds

0.00

**\*170\***

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

**\*180\***

QC

Memo

0.00

Quality Control

CC 12/3/26  
BB

8/2/3/27

8/2/3/27

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Work Order ID 81394

**\*81394\***

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March-14-12 7:46:33 AM

Item ID: D350-636-011

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop

**\*NS2\***

Start Date: 13/03/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

Pressure Wash per QSI005 4.3

0.00

**\*190\***

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

*IX M-12/03/28*

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*200\***

Powdercoat

Memo

0.00

Powder Coating

START TIME: 8h25  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 8h55

*m120 222*

*1 Q @ 12/03/29*

210

QC Inspect ~~Chemical Conversion Coat~~ *Powder*

0.00

**\*210\***

QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

*IX M-12/04/03*

# Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 81394

\*81394\*

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March-14-12 7:46:33 AM

Item ID: D350-636-011

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Skidtube LH

Stop \*NS2\*

Start Date: 13/03/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

220

0.00

\*220\*

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1- Install inserts as per Dwg D2750

IXP M/L 12/04/03

230

0.00

\*230\*

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: N/A

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH:

EXP DATE:

120318  
12/08

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch:

12/08 M110348  
M114596

5-Coat all exposed fasteners with "LPS Procyon"

batch:

# Dart Aerospace Ltd

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# Work Order ID 81394

**\*81394\***

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March-14-12 7:46:33 AM

Item ID: D350-636-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop **\*NS2\***

Start Date: 13/03/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00

**\*240\***

QC

Memo

0.00

Quality Control

250

Pick Kit

0.00

**\*250\***

Packaging

Memo

0.00

Packaging

1x SP 12-04-09

260

QC4- 100% Inspect kits for completeness

0.00

**\*260\***

QC

Memo

0.00

Quality Control

\*\*\*\*\*ensure antiseize is on AN8C21A bolts\*\*\*\*\*



# Dart Aerospace Ltd

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube LH

Start Date: 13/03/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

270

0.00

**\*270\***

Packaging

Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-011

*OK I*

280

0.00

**\*280\***

QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

*12/4/10**12/4/10**mf*  
*12-04-09*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Picklist Print

March-14-12 7:46:36 AM

Page 1

Work Order ID: 81394

\*81394\*

Parent Item: D350-636-011

\*D350-636-011\*

Parent Item Name: Skidtube LH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev:J 06-03-23 As per Rev D JLM  
 IPP Rev:K 06-07.13 As per dsi9343 EC  
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC  
 IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:EC  
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec  
 IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010  
 DD verf:EC IPP Rev:P 10.06.22 revise  
 seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH  
 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3492-1

Manufactured

No

230

Each

130.0000

8

8

\*D3492-1\*

Plug

\*\*

M-L 12/04/03

Location

Loc Qty

Loc Code

FP002

130

69531

8

74444

2

76235

20

77037 ✓

100

D3492-3

Manufactured

No

230

Each

69.0000

8

8

\*D3492-3\*

Plug

\*\*

el 12/04/09

Location

Loc Qty

Loc Code

FP-A

69

78600

69

1381967

x8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 2

Work Order ID: 81394

**\*81394\***

Parent Item: D350-636-011

**\*D350-636-011\***

Parent Item Name: Skidtube LH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

209.0000

8

8

**\*NAS1611-010\***

O-RING

121166

\*\*

8 M/L 12/04/03

Location

Loc Qty

Loc Code

FP

50

110915

0

120770

50

FP001

159

110915

14

117460

8

118077

1

118612

3

119438

47

120308

36

120986

50

NAS1149D0863J

Purchased

No

250

Each

231.0000

2

2

**\*NAS1149D0863.J\***

WASHER

\*\*

Sp 12-04-09.

Location

Loc Qty

Loc Code

ST298

231

118078

36

119307

95

120308

100

2x

D2744

Manufactured

No

110

Each

60.0000

1

1

**\*D2744\***

Cap

\*\*

BE 12/03/22

Location

Loc Qty

Loc Code

LG002

60

62715

1

70881

10

71861

7

78900

42

1

March-14-12 7:46:36 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 81394

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

**\*81394\***

**\*D350-636-011\***

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT

Manufactured No

110 Each

26.0000

1

1

**\*D2600-3-BENT\***

Extrusion Bent

\*\*

(1) GST-12-03-22

Location

Loc Qty

Loc Code

LG

26

66875

7

73253

1

75021

1

75022

1

75023

1

81330

15

D2743

Manufactured No

160 Each

248.0000

8

8

**\*D2743\***

Crossbolt Spacer

\*\*

BE12/03/23

Location

Loc Qty

Loc Code

LG001

248

67766

4

68251

3

73403

64

74445

1

78603

76

79517

100

D2739

Manufactured No

160 Each

8.0000

1

1

**\*D2739\***

350 I Beam

\*\*

Location

Loc Qty

Loc Code

LG

8

72155

1

80082

7

81508

1

7/6-12-3-32

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 81394

**\*81394\***

Parent Item: D350-636-011

**\*D350-636-011\***

Parent Item Name: Skidtube LH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3490-3 Manufactured No

160 Each 38.0000 4 4

**\*D3490-3\***

Cross Bolt Spacer

\*\*

BE 12/03/23

Location

Loc Qty

Loc Code

LG001

38

78800

38

4

D3490-1 Manufactured No

160 Each 49.0000 4 4

**\*D3490-1\***

Cross Bolt Spacer

\*\*

BE 12/03/23

Location

Loc Qty

Loc Code

LG001

49

62450

2

74875

4

77042

3

78793

40

4

ALS4-1032-225 Purchased No

220 Each 1,134.000 38 38

**\*ALS4-1032-225\***

Insert

\*\*

m-h 12/04/03

Location

Loc Qty

Loc Code

ST281

1021

108696

146

110768

62

118386

55

118966

68

120671 ✓

690

38

ST282

113

120410

100

120451

13

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 81394

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

**\*81394\***

**\*D350-636-011\***

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230

Each

26.0000

1

1

**\*D3793-3\***

Wearshoe

\*\*

*m.p. 12/04/03*

Location

Loc Qty

Loc Code

FP001

12

80434

12

FP002

14

78935 ✓

14

AN8C35A

Purchased No

230

Each

65.0000

1

1

**\*AN8C35A\***

BOLT

\*\*

*m.p. 12/04/03*

Location

Loc Qty

Loc Code

FP002

64

115960

1

117834

10

118286 ✓

53

ST346

1

114442

0

115188

0

115960

1

D3793-1

Manufactured No

230

Each

18.0000

1

1

**\*D3793-1\***

Wearshoe

\*\*

*m.p. 12/04/03*

Location

Loc Qty

Loc Code

FP001

18

77029 ✓

6

78901

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 81394

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

**\*81394\***

**\*D350-636-011\***

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3488-041

Manufactured No

230 Each

17.0000 1 1

**\*D3488-041\***

Blade Fitting Assembly, LH

\*\*

*m-l 12/04/03*

Location

Loc Qty

Loc Code

FP002

17

61689 ✓

1

75056 ✓

7

77021

9

D3794-3

Manufactured No

230 Each

31.0000 1 1

**\*D3794-3\***

Gasket

\*\*

*m-l 12/04/03*

Location

Loc Qty

Loc Code

FP002

31

74530

2

78895 ✓

5

80436 ✓

24

AN6C44A

Purchased No

230 Each

107.0000 4 4

**\*AN6C44A\***

BOLT

\*\*

*m-l 12/04/03*

Location

Loc Qty

Loc Code

FG

2

103964

2

ST343

105

120095

12

120143

25

120465

27

120641 ✓

21

121013

20

*4*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 81394

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

**\*81394\***

**\*D350-636-011\***

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

85.0000

1

1

**\*MS21083C8\***

NUT

\*\*

m-l 12/04/03

Location

Loc Qty

Loc Code

FP002

1

115884

1

ST303

14

115884

0

118077

1

119309

2

119436 ✓

9

119638

2

ST304

70

120142

20

120731

25

121011

25

D3536-25

Manufactured

No

230

Each

16.0000

1

1

**\*D3536-25\***

Gasket

\*\*

m-l 12/04/03

Location

Loc Qty

Loc Code

FP002

16

78902 ✓

16

D3631-1

Manufactured

No

230

Each

223.0000

8

8

**\*D3631-1\***

Washer

\*\*

m-l 12/04/03

Location

Loc Qty

Loc Code

ST072

223

68062 ✓

2

75548 ✓

221

8

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 81394

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

**\*81394\***

**\*D350-636-011\***

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3791-1 Manufactured No

230 Each 17.0000 1 1

**\*D3791-1\***

Wearplate

\*\*

M-L 12/04/03

Location

Loc Qty

Loc Code

FP002

17

62239

2

75041

3

78897

12

AN960C10L NAS1149C0332 Purchased No

230 Each 0.0000 38 38

**\*AN960C10I \***

washer

D2745

Manufactured No

230 Each 136.0000 8 8

**\*D2745\***

Bushing

\*\*

M 118354

M-L 12/04/03 \*

\*\*

M-L 12/04/03

Location

Loc Qty

Loc Code

FP

100

79518

100

FP001

36

69529

1

76142

1

78597

34

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 81394

**\*81394\***

Parent Item: D350-636-011

**\*D350-636-011\***

Parent Item Name: Skidtube LH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

230

Each

998.0000

34

34

**\*AN3C5A\***

Bolt

\*\*

m-p 12/04/03

Location

Loc Qty

Loc Code

FP001

7

115835

7

ST350

991

116419

28

117343

13

117764

7

117872

2

119749

23

120423 ✓

918

D3537-1

Manufactured

No

230

Each

151.0000

3

3

**\*D3537-1\***

Wearpad

\*\*

m-p 12/04/03

Location

Loc Qty

Loc Code

FP001

104

79833 ✓

50

79835 ✓

54

FP002

47

69817

5

79834

42

NAS1149C0832R

Purchased

No

230

Each

304.0000

1

1

**\*NAS1149C0832R\***

WASHER

\*\*

m-p 12/04/03

Location

Loc Qty

Loc Code

ST297

304

114915 ✓

304

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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 81394

\*81394\*

Parent Item: D350-636-011

\*D350-636-011\*

Parent Item Name: Skidtube LH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

623.0000

4

4

**\*AN3C6A\***

BOLT

\*\*

M-L 12/04/03

Location

Loc Qty

Loc Code

FP001

1

111982

1

ST351

622

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

13

119449

21

120423 ✓

133

120693

400

4

NAS1611-013

Purchased

No

230

Each

168.0000

8

8

**\*NAS1611-013\***

O-RING

\*\*

ll 11/04/09

X

Location

Loc Qty

Loc Code

FP001

168

116582

5

117291

2

117887

53

119623

36

120360

22

120910

50

11121166

X8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 81394

**\*81394\***

Parent Item: D350-636-011

**\*D350-636-011\***

Parent Item Name: Skidtube LH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230 Each

19.0000 1 1

**\*D3535-25\***

Wearshoe

\*\*

*m.d 12/04/03*

Location

Loc Qty

Loc Code

FP001

14

62233 ✓

1

80331 ✓

13

FP002

5

77617

5

D3794-1

Manufactured No

230 Each

24.0000 1 1

**\*D3794-1\***

Gasket

\*\*

*m.d 12/04/03*

Location

Loc Qty

Loc Code

FP002

24

75042 ✓

12

80435

12

MS21043-6

Purchased No

230 Each

809.0000 4 4

**\*MS21043-6\***

NUT

\*\*

*m.d 12/04/03*

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

789

112314 ✓

83

117887

6

118384

200

120308

500

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 81394

**\*81394\***

Parent Item: D350-636-011

**\*D350-636-011\***

Parent Item Name: Skidtube LH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Manufactured No

250

Each

66.0000

2

2

**\*D3493-1\***

Washer

\*\*

*SP*

*[Signature]*

Location

Loc Qty

Loc Code

ST050

66

70697

2

77573

24

78835

40

*2x*

MS21083C8

Purchased No

250

Each

85.0000

2

2

**\*MS21083C8\***

NUT

\*\*

*SP*

*[Signature]*

Location

Loc Qty

Loc Code

FP002

1

115884

1

ST303

14

115884

0

118077

1

119309

2

119436

9

119638

2

ST304

70

120142

20

120731

25

121011

25

*2x*

AN8C21A

Purchased No

250

Each

51.0000

2

2

**\*AN8C21A\***

BOLT

\*\*

*SP 12-04-09*

Location

Loc Qty

Loc Code

ST343

51

118758

5

120094

42

120872

4

*2x*

March-14-12 7:46:37 AM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 81394

**\*81394\***

Parent Item: D350-636-011

**\*D350-636-011\***

Parent Item Name: Skidtube LH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

184.0000

4

4

**\*NAS1515H3I \***

WASHER

\*\*

M-12/04/03

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

144

118686

3

119438

1

120072 ✓

40

120360

100

D2741

Manufactured

No

250

Each

37.0000

1

1

**\*D2741\***

Blade, 350 Skidtube

\*\*

SP

12-04-09

Location

Loc Qty

Loc Code

ST

-10

ST466

47

71856

1

76984

36

D3532-1

Manufactured

No

250

Each

39.0000

2

2

**\*D3532-1\***

Spacer

\*\*

SP 12-04-09

2x

Location

Loc Qty

Loc Code

ST053

39

78839

39

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

# GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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WITHOUT NOTICE  
WORK ORDER

NO. 81394 MCLJ

12/03/14

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F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AST SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEC 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RA	DART AEROSPACE USA, INC.	
DRAWN	RA	PORT HADLOCK, WA	
CHECKED	RA	DRAWING NO.	REV. F
MFG. APPR.	RA	D2750	SHEET 1 OF 11
APPROVED	RA	TITLE	SCALE
DE APPR.	RA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

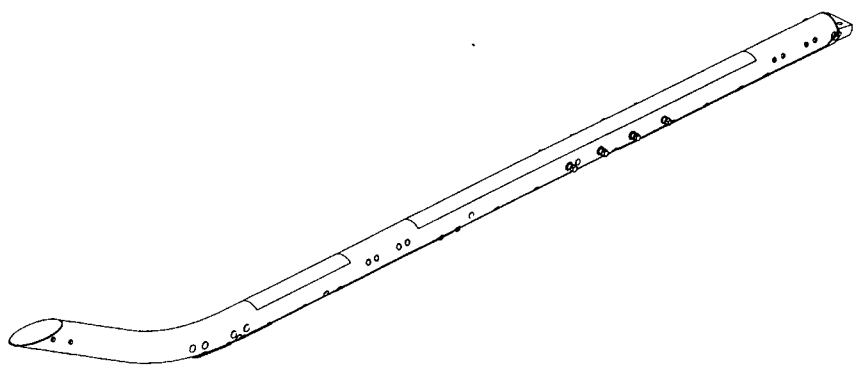
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

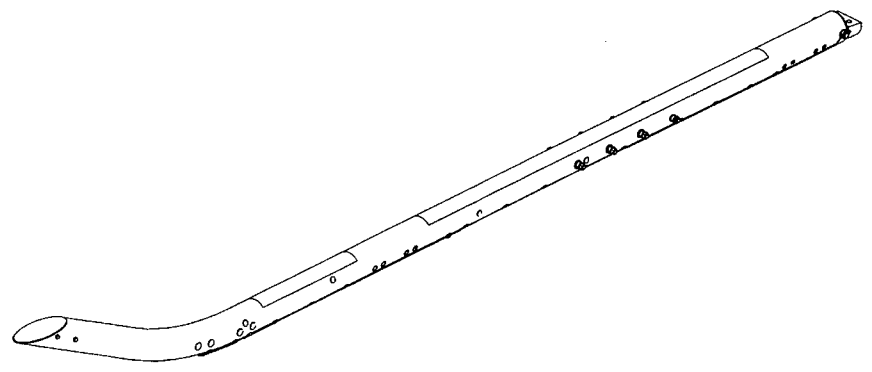
**NOTE:** Date & initial all entries



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D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

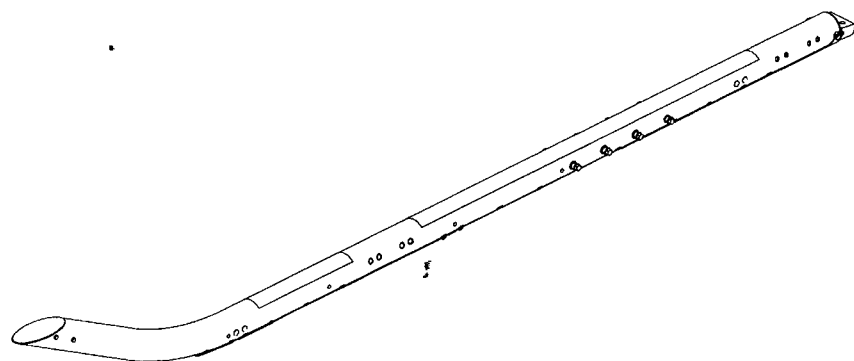
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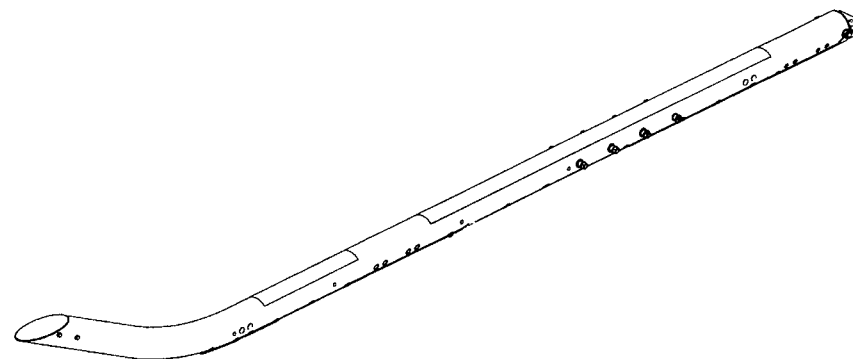
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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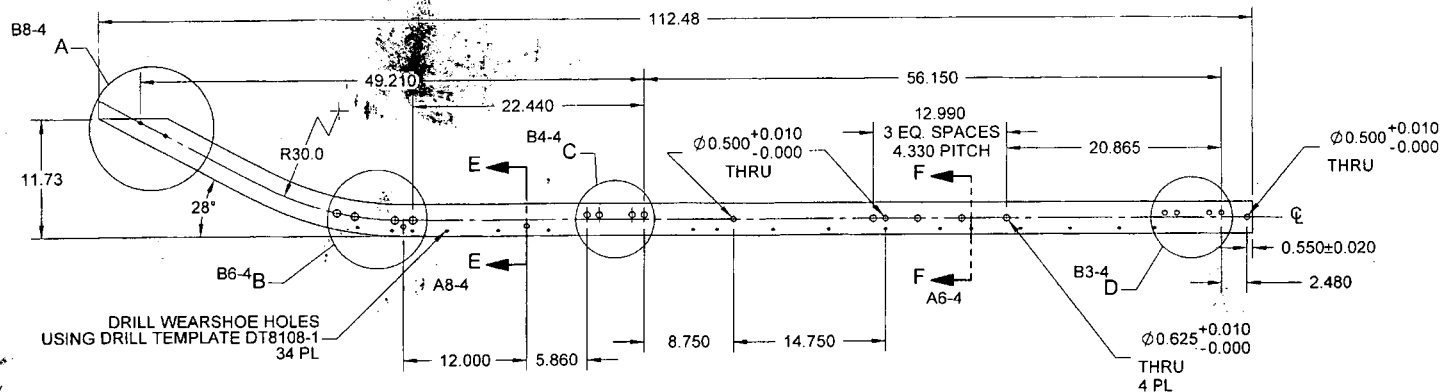
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

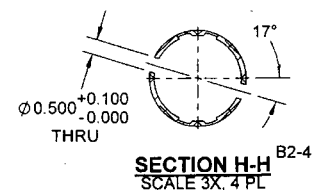
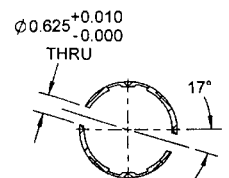
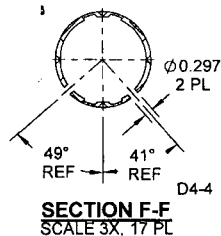
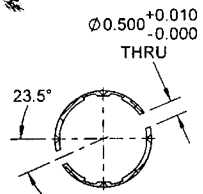
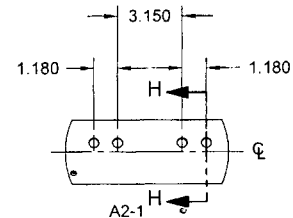
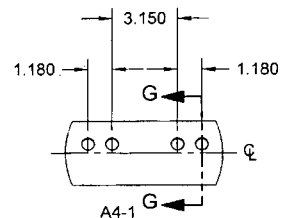
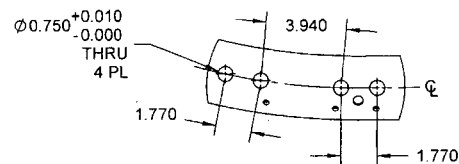
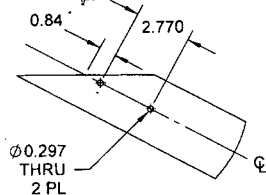
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**D2750-1 LH SKIDTUBE**



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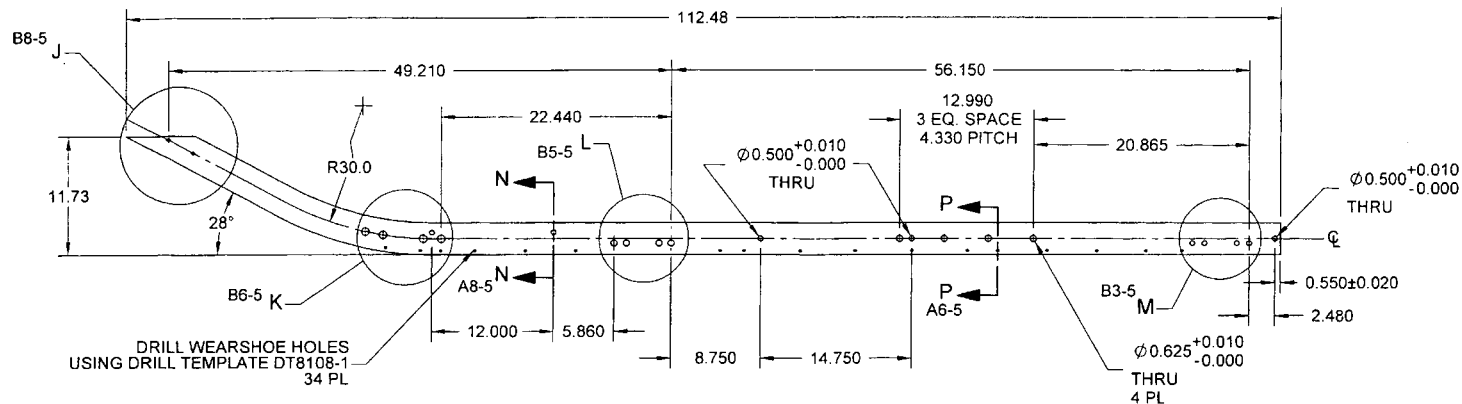
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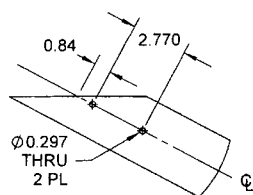
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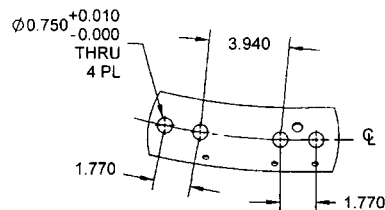
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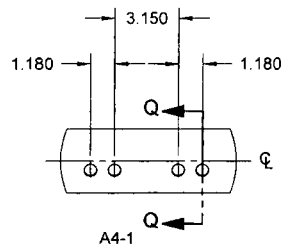
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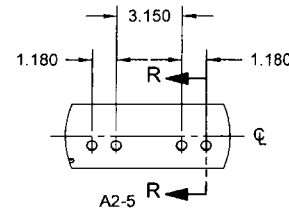
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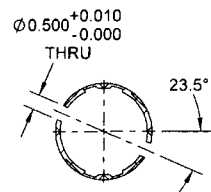
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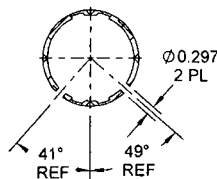
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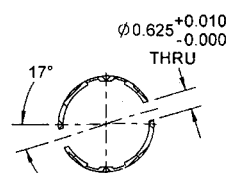
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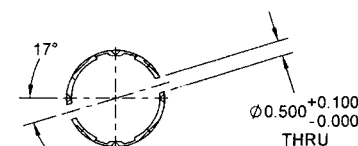
**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



**SECTION R-R**  
SCALE 3X, 4 PL

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MFG. APPR.		<b>D2750</b>	SHEET 5 OF 11
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DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

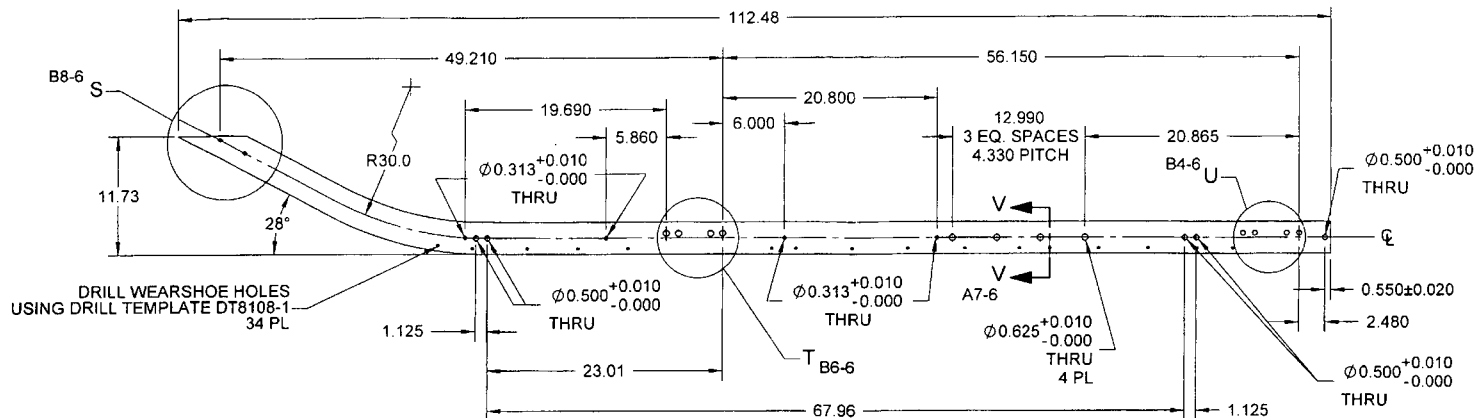
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

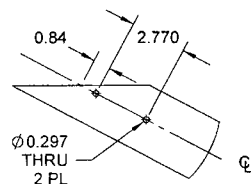
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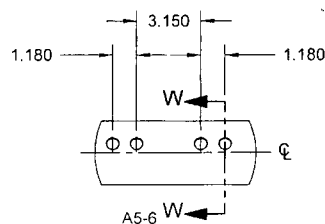
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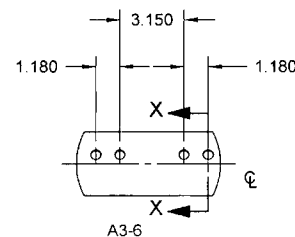
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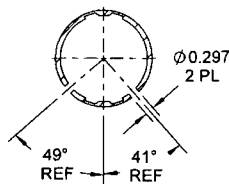
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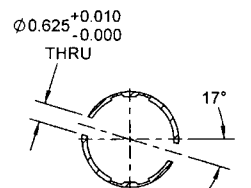
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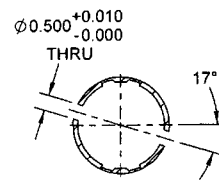
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SCALE 2X



**SECTION V-V**  
SCALE 3X, 17 PL



**SECTION W-W**  
SCALE 3X, 4 PL



**SECTION X-X**  
SCALE 3X, 4 PL

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MFG. APPR.		REV. F
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

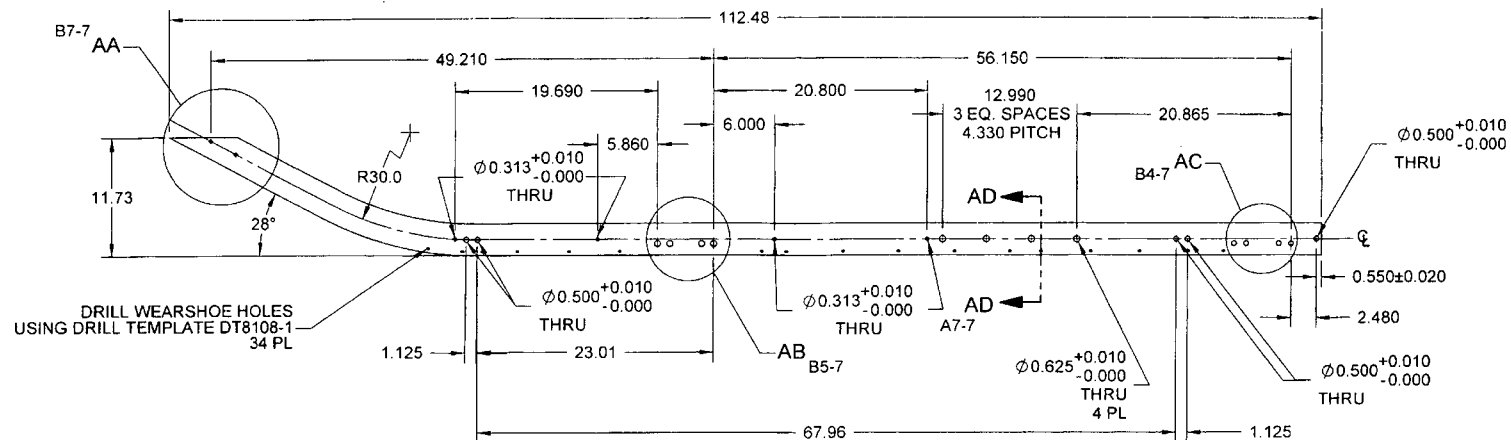
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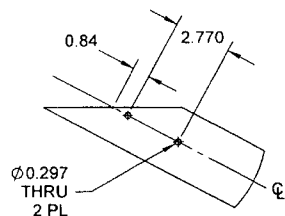
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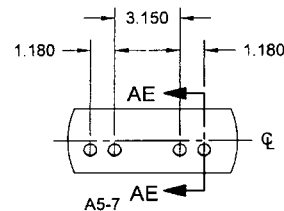
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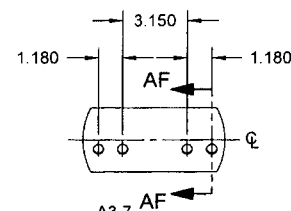
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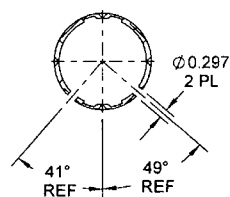
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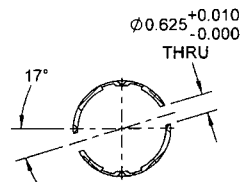
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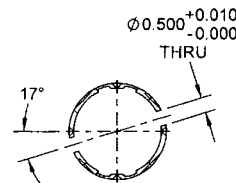
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SCALE 2X



**SECTION AD-AD**  
SCALE 3X, 17 PL



**SECTION AE-AE**  
SCALE 3X, 4 PL



**SECTION AF-AF**  
SCALE 3X, 4 PL

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08-09-2018

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MFG. APPR.			SHEET 7 OF 11
APPROVED		TITLE <b>350 SKIDTUBE ASSEMBLY</b>	SCALE
DE APPR.			NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DESIGN	<i>PH</i>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA  DRAWING NO. <b>D2750</b>  TITLE <b>350 SKIDTUBE ASSEMBLY</b>  COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND NOT FOR DISTRIBUTION AND IS SUPPLIED TO THE CUSTOMER COMPANY WITHOUT BEING USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON THEREOF	REV. F
DRAWN	<i>PH</i>		SHEET 8 OF 11
CHECKED	<i>[Signature]</i>		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	08.07.16		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

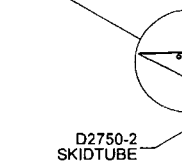
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

A1-9 AM



D2750-2 SKIDTUBE  
AFTER FINISH, ALS4-1032-225 INSERT 34 PL

BLACK ANTI-SKID

AN

AP

AQ

A7-9

13

REFER TO SECTION AP-AP

AN6C44A BOLT  
D2745 BUSHING  
D3631-1 WASHER  
D2745 BUSHING  
MS21043-6 NUT 4 PL  
(INSTALL NUT ON THIS SIDE)

BOND D2739 WEB INTO D2750-2 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015. NOTE: ENSURE THAT HOLES LINE UP.

2.0 TYP

1.78 TO D2739 WEB

D3488-042 BLADE FITTING

AN8C35A BOLT  
D3793-3 WEARSHOE, REF  
D3794-3 GASKET, REF  
D3488-042 BLADE FITTING, REF  
D3794-3 GASKET, REF  
D3793-3 WEARSHOE, REF  
AN960C815L WASHER  
MS21083C8 NUT  
(INSTALL NUT ON THIS SIDE)

D3794-1 GASKET

D3793-1 WEARSHOE

AN3C5A BOLT  
AN960C10L WASHER 34 PL

D3537-1 WEARPAD

D3791-1 WEARPLATE

D3536-25 GASKET

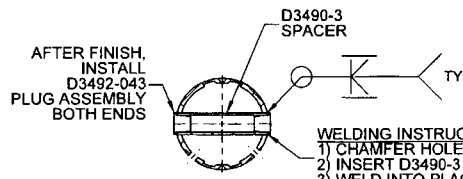
D3535-25 WEARSHOE

D3537-1 WEARPAD

D3794-3 GASKET

D3793-3 WEARSHOE

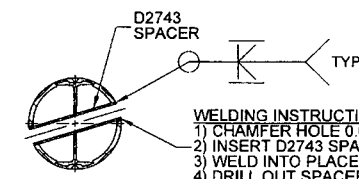
# **D2750-042 350 SKIDTUBE ASSEMBLY, RH**



AFTER FINISH, INSTALL D3492-043 PLUG ASSEMBLY BOTH ENDS

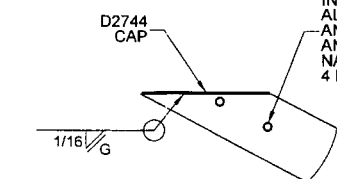
WELDING INSTRUCTIONS  
1) CHAMFER HOLE 0.050 X 45°  
2) INSERT D3490-3 SPACER (Ø 0.750 HOLES)  
3) WELD INTO PLACE, GRIND FLUSH

**SECTION AN-AN**  
SCALE 3X, 4 PL



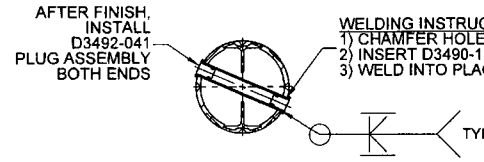
**SECTION AQ-AQ**  
SCALE 3X, 4 PL

WELDING INSTRUCTIONS  
1) CHAMFER HOLE 0.050 X 45°  
2) INSERT D2743 SPACER (Ø 0.625 HOLES)  
3) WELD INTO PLACE, GRIND FLUSH  
4) DRILL OUT SPACER TO Ø 0.484



AFTER FINISH, INSTALL ALS4-1032-225 INSERT AN3C6A BOLT AN960C10L WASHER NAS1515H3L WASHER 4 PL

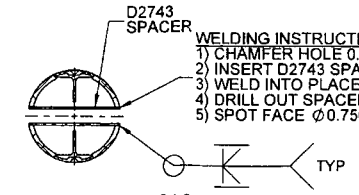
**DETAIL AM**  
SCALE 2X



AFTER FINISH, INSTALL D3492-041 PLUG ASSEMBLY BOTH ENDS

WELDING INSTRUCTIONS  
1) CHAMFER HOLE 0.050 X 45°  
2) INSERT D3490-1 SPACER (Ø 0.500 HOLES)  
3) WELD INTO PLACE, GRIND FLUSH

**SECTION AP-AP**  
SCALE 3X, 4 PL



**SECTION AR-AR**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)

WELDING INSTRUCTIONS  
1) CHAMFER HOLE 0.050 X 45°  
2) INSERT D2743 SPACER (Ø 0.625 HOLES)  
3) WELD INTO PLACE, GRIND FLUSH  
4) DRILL OUT SPACER TO Ø 0.484  
5) SPOT FACE Ø 0.750 (BOTH SIDES)

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CHECKED		DRAWING NO. <b>D2750</b>	REV. F
MFG. APPR.		TITLE <b>350 SKIDTUBE ASSEMBLY</b>	SHEET 9 OF 11
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08-09-2016

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

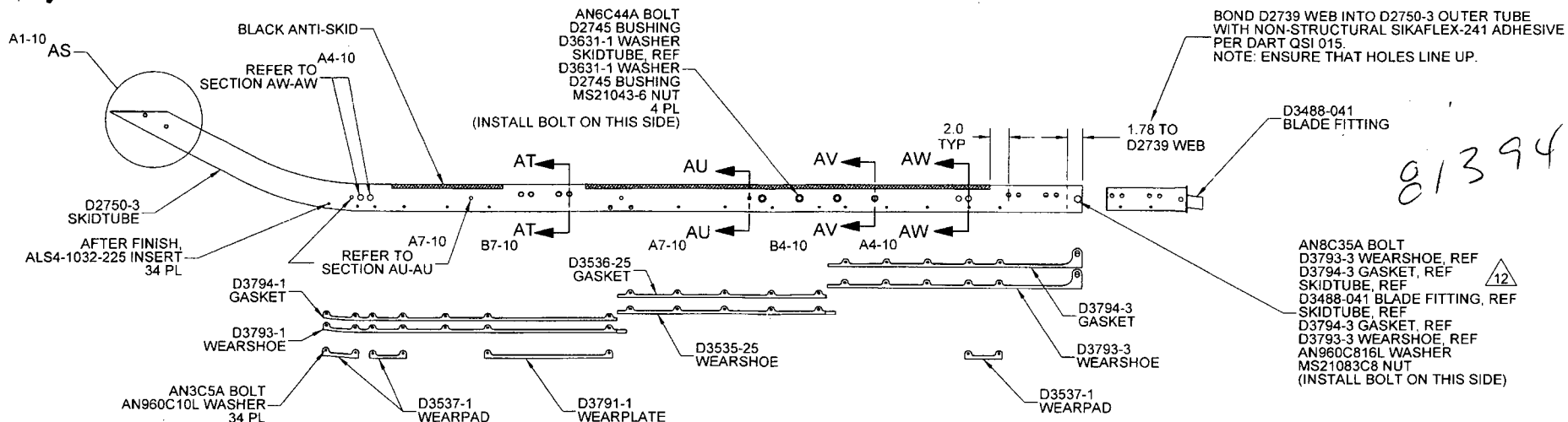
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

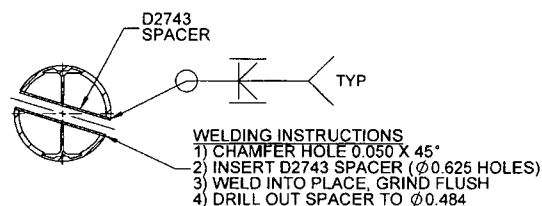
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

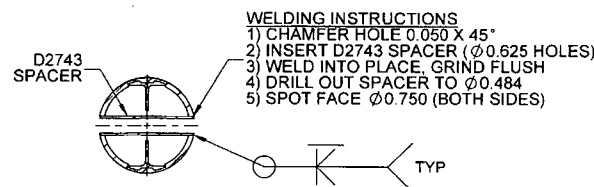




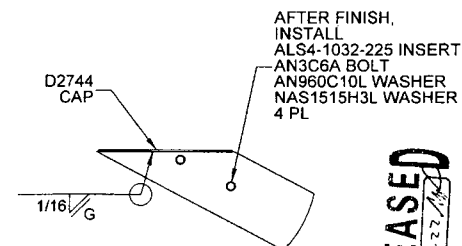
### D2750-043 350 SKIDTUBE ASSEMBLY, LH



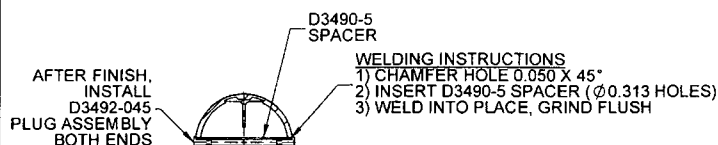
**SECTION AT-AT**  
SCALE 3X, 4 PL



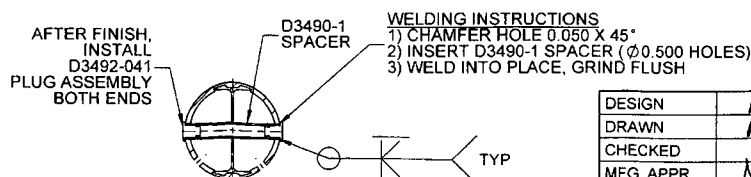
**SECTION AV-AV**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**DETAIL AS**  
SCALE 2X



**SECTION AU-AU**  
SCALE 3X, 4 PL



**SECTION AW-AW**  
SCALE 3X, 4 PL

DESIGN	RE	<b>DART AEROSPACE USA, INC.</b>	
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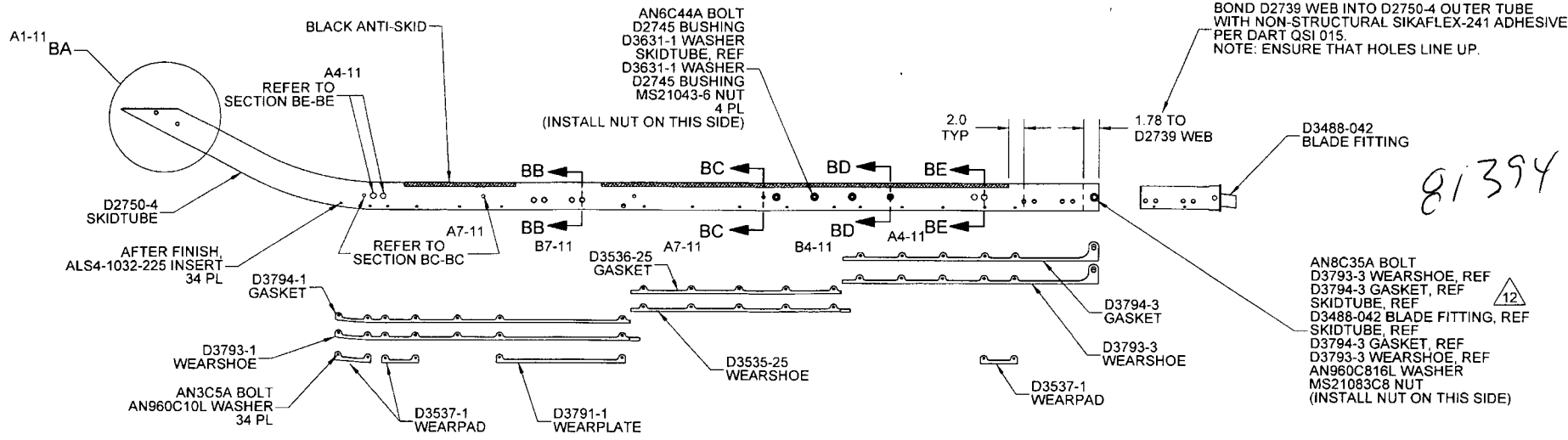
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

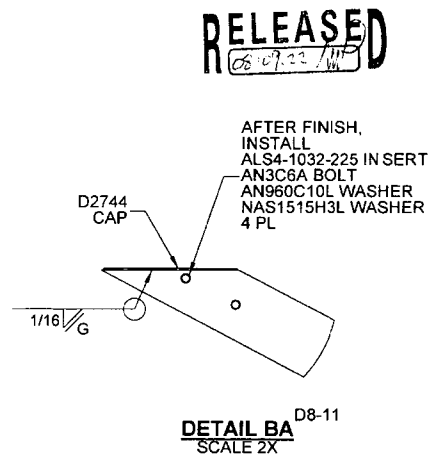
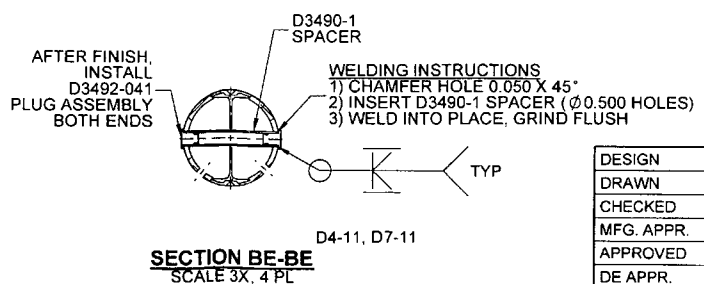
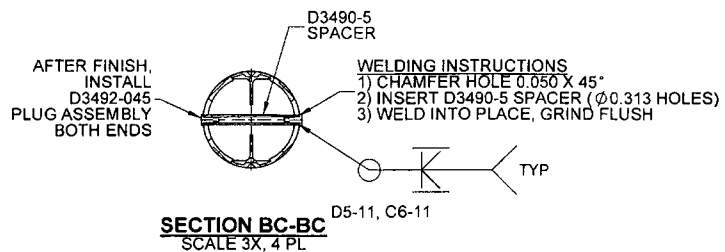
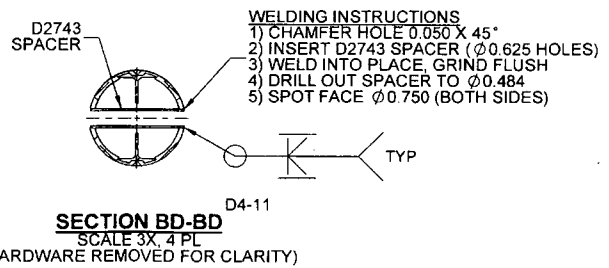
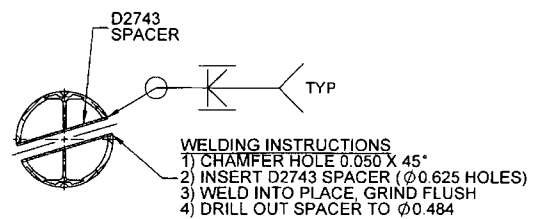
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D2750-044 350 SKIDTUBE ASSEMBLY, RH**



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W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

NO. 282

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 78413  
Part number: A350-636-011  
Description: Skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier David Newell Date of Test Coupon 12.02.01  
Welder Barclay Elliott Date of Test Coupon 12.02.01

The above named individual is qualified in accordance with AWS D17.1.2001 to weld